



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

654.2801

Job Sheet 204546



Part No: 654.2801

Job Qty: 10 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: AOG

Job Created: 12/12/19

Job Tracking No:

Due Date: 12/16/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG 654.2800 Rev.N/C IPP Rev. A 19.11.28 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	10 pcs		12/16/19	0.17	2.00	Waterjet - Flow		Dec 19/12/14
120	QC 2	10 pcs		12/16/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		Dec 19/12/14
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Rush!!!

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130 QC 8	10 pcs	12/16/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	B- 19-12-H
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
135 Small Fab - Brake NC - B4B	10 pcs	12/16/19	0.00 1.67	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	DAS
				Small Fab - 3 - B4B	30
				Small Fab - 4 - B4B	9-89
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
140 QC 5	10 pcs	12/16/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				DAS	
				DEC 13 2019	
				9-89	
					Plex 12/12/19 11:46 AM Dart.Renwick.Jennife

145 Handfinish - 1-1 Chemical-B4B	10 pcs	12/18/19	0.00 0.67	QC 5 - 81		
				Handfinish - 1 - 1 - B4B		
				Handfinish - 1 - 2 - B4B		
				Handfinish - 1 - 3 - B4B		
				Handfinish - 1 - 4 - B4B	SA DEC 16 2019	
				Handfinish - 1 - 5 - B4B		
				Handfinish - 1 - 6 - B4B		
				Handfinish - 1 - 7 - B4B		
				Handfinish - 1 - 8 - B4B		
				Handfinish - 1 - 9 - B4B		
				Handfinish - 1 - 10 - B4B		
				Handfinish - 1 - 11 - B4B		
				Handfinish - 1 - 12 - B4B		
				Handfinish - 1 - 13 - B4B		
				Handfinish - 1 - 14 - B4B		
				Handfinish - 1 - 15 - B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
Handfinish - 1 - 22 - B4B						
146 QC 7	10 pcs	12/18/19	0.00 0.00	QC 7 - 10		
				QC 7 - 13		
				QC 7 - 14		
				QC 7 - 15		
				QC 7 - 17		
				QC 7 - 18		
				QC 7 - 19		
				QC 7 - 2		
				QC 7 - 28		
				QC 7 - 3		
				QC 7 - 30		
				QC 7 - 34	BL 19-10-16	
				QC 7 - 36		
				QC 7 - 37		
				QC 7 - 41		
				QC 7 - 47		
				QC 7 - 48		
				QC 7 - 51		
				Plex 12/16/19 10:01 AM dart.boucher.sylvie		

150 Small Fab - 2 - B4B	10 pcs	12/16/19	0.00 1.00	QC 5 - 81	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
160 QC 5	10 pcs	12/16/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
170 Handfinish - 1-1 Chemical- B4B	10 pcs	12/16/19	0.00 0.67	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 -	

DEC 16 2019

DAS
DEC 16 2019 68
9-89DAS
03
9-89Soy
145

See Attached E-mail
For Deviation.
Aldine 1200 Acceptable
J.M. 19.12.12

					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
150	Small Fab - 2 - B4B	10 pcs	12/18/19	0.00 1.00	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
160	QC 5	10 pcs	12/18/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
190	Powdercoat - 6 Fire Red - B4B	10 pcs	12/18/19	0.00 0.50	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
200	QC 3	10 pcs	12/18/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	

NOT REQUIRED
12-19-16

24/19-12-16

DAS
03
9-09

Seq 146

						B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
180	QC 7	10 pcs	12/16/19	0.00	0.00	QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
						QC 7 - 28	
						QC 7 - 3	
						QC 7 - 30	
						QC 7 - 34	
						QC 7 - 36	
						QC 7 - 37	
						QC 7 - 41	
						QC 7 - 47	
						QC 7 - 48	
						QC 7 - 51	
						QC 7 - 58	
						QC 7 - 59	
						QC 7 - 60	
						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
						QC 7 - 61	
						QC 7 - 81	
						QC 7 - 76	
						QC 7 - 79	
190	Powdercoat - 6 Fire Red - B4B	10 pcs	12/16/19	0.00	0.50	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
200	QC 3	10 pcs	12/16/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	

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					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	DAS DEC 15 2019 40 9-89
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
230 Packaging 3-1 - Stock - B4B	10 pcs	12/18/19	0.00	0.00	Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 -	

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					B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
240 QC 21 - SA	10 pcs	12/16/19	0.00	0.00	QC 21 - SA - 21	DAS 21
					QC 21 - SA - 70	8.22
					QC 21 - SA - 53	

DEC 16 2019

Part Op 110 - 1-Cut as per Dwg Dwg Rev: N/C Prog Rev: N/C 2-Deburr.

Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

135 - (Small Fab) 1-Form as per drawing

140 - (QC5- Inspect part completeness to step on W/O)

150 - Assemble as per drawing.

160 - (QC5- Inspect part completeness to step on W/O)

170 - Acid etch and ALODINE as per QSI 005 4.1

180 - (QC7-Inspect Chemical Conversion Coat)

190 - Powder coat - 6 Fire Red START TIME: 1:50 OVEN TEMPERATURE: 320° FINISH TIME: 2:20

200 - (QC3- Inspect Part Finish)

230 - (Identify as per dwg & Stock Location:

240 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	3.4000 sf (.34 ea)	110-Waterjet - Flow - 1	S180490
CR3213-4-3	Rivet, Cherry	40 Ea (4 ea)	135-Small Fab - Brake NC - B4B	
CR3213-4-3	Rivet, Cherry	40 Ea (4 ea)	150-Small Fab - 2 - B4B	F11.036042

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M2024T3S.063	3	100	0
135-Small Fab - Brake NC - B4B	CR3213-4-3	40	433	0
150-Small Fab - 2 - B4B	CR3213-4-3	40	433	0

Part Specifications

Specifications could not be found.

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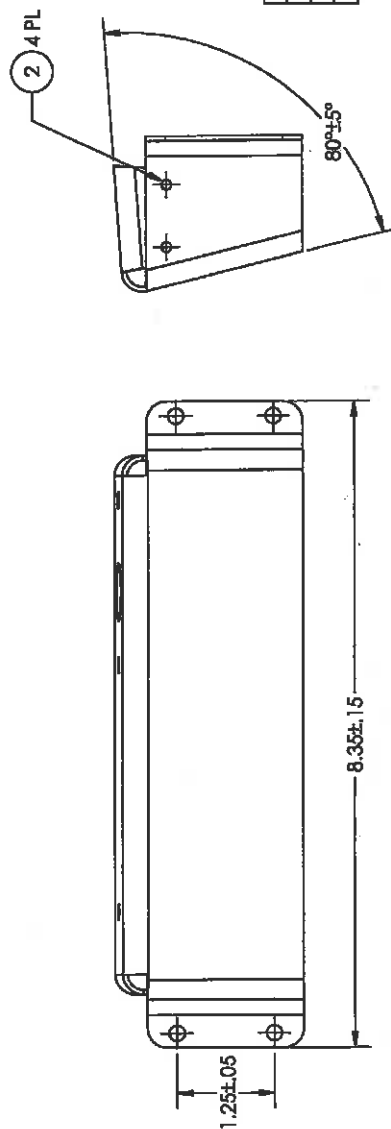
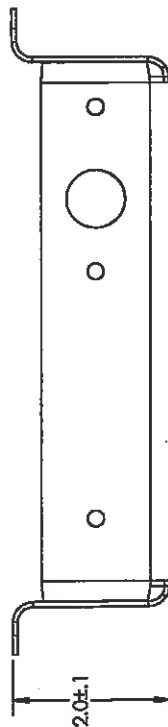
MATERIAL: ALUMINUM 2024-T3 OR EQUIVALENT

2/ FINISH: LAW MPP-172 SECTION 3.3, 4.3, AND 5.3; 4-5 mm MAX THICKNESS

3. IDENTIFY PER MPP-120

4. ALTERNATIVE P/N 601.4049

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 204546



654.2801

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
N/C	INITIAL RELEASE	11-27-19	FOR P. BRAVO

4	2	CR3213-4-3	RIVET			
1	1	454.2810	BRACKET			
X			BRACKET ASSY			
2801	FIN	PART #	DESCRIPTION		MAT'L	SPEC

[illegible]

Jean-Luc Menard

From: Tyler Cross
Sent: Thursday, December 12, 2019 2:02 PM
To: Jennifer Renwick; Steven Hemmerich; Jean Francois Sauve
Cc: Linda Lacelle; Konrad Sauve; Daniel Paquette; Jean-Luc Menard
Subject: RE: Bracket -Potential AOG situation-

The only deviation will be note 2. The N/C drawing is the released version of the drawing.

Deviation: Finish in accordance to QSI005-11L Section 4.1.2.2 Alodine 1200 and Section 4.3 color fire red

Tyler

From: Jennifer Renwick <jrenwick@dartaero.com>
Sent: Thursday, December 12, 2019 8:39 AM
To: Tyler Cross <tcross@dartaero.com>; Steven Hemmerich <shemmerich@dartaero.com>; Jean Francois Sauve <jfsauve@dartaero.com>
Cc: Linda Lacelle <llacelle@dartaero.com>; Konrad Sauve <ksauve@dartaero.com>; Daniel Paquette <dpaquette@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>
Subject: RE: Bracket -Potential AOG situation-

Can you please send me the deviation and confirm the drawing attached is the good one? I will attach to the job.

Thank you,
Jen

From: Jennifer Renwick
Sent: Thursday, December 12, 2019 11:35 AM
To: Jean-Luc Menard <jmenard@dartaero.com>; Daniel Paquette <dpaquette@dartaero.com>; Tyler Cross <tcross@dartaero.com>; Steven Hemmerich <shemmerich@dartaero.com>; Jean Francois Sauve <jfsauve@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Konrad Sauve <ksauve@dartaero.com>
Subject: RE: Bracket -Potential AOG situation-

Will do.

From: Jean-Luc Menard <jmenard@dartaero.com>
Sent: Thursday, December 12, 2019 11:33 AM
To: Daniel Paquette <dpaquette@dartaero.com>; Tyler Cross <tcross@dartaero.com>; Steven Hemmerich <shemmerich@dartaero.com>; Jean Francois Sauve <jfsauve@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Konrad Sauve <ksauve@dartaero.com>; Jennifer Renwick <jrenwick@dartaero.com>
Subject: RE: Bracket -Potential AOG situation-

Hi Jen,
Pls issue qty 10 and I will get the w/o from you.
654.2801
THX
JL

